

Date: Monday, 06/10/2008 1:20:16 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WHEEL ASSEMBLY		
Job Number	: 42464			Part Number	: D3233041		
Estimate Number	: 12099			Drawing Number	: D3233 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/10/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 20/10/2008	Qty:	6
Previous Run	: 37638			Um:	Each		
Written By	:						
Checked & Approved By	: <u>SCD 08.10.06</u>						
Comment	: Est. C 05.07.18 D3233-5 was D3332-5; Qty changed by half K			JJLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D32335	Hub Sleeve 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Hub Sleeve Pick: Qty Part Number Description Batch 1 D3233-5 Hub Sleeve <u>B37647</u> SAN 08/11/03 6
2.0	D32337	Shaft Sleeve 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Shaft Sleeve Pick: Qty Part Number Description Batch 1 D3233-7 Shaft Sleeve <u>B37648</u> SAN 08/11/03 6
3.0	D32339	Tire & Rim Assembly 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Tire & Rim Assembly Pick: Qty Part Number Description Batch 1 D3233-9 Tire & Rim Assembly <u>B37649</u> SAN 08/11/03 6
4.0	NKI 3020	BEARING 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s) Bearing Pick: Qty Part Number Description Batch 2 NKI 30/20 Bearing & Inner Sleeve <u>M109645 - 4</u> SAN 08/11/03 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

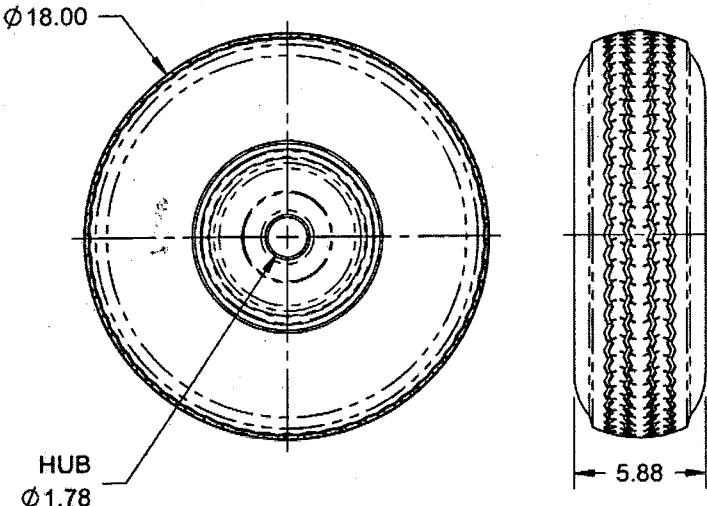
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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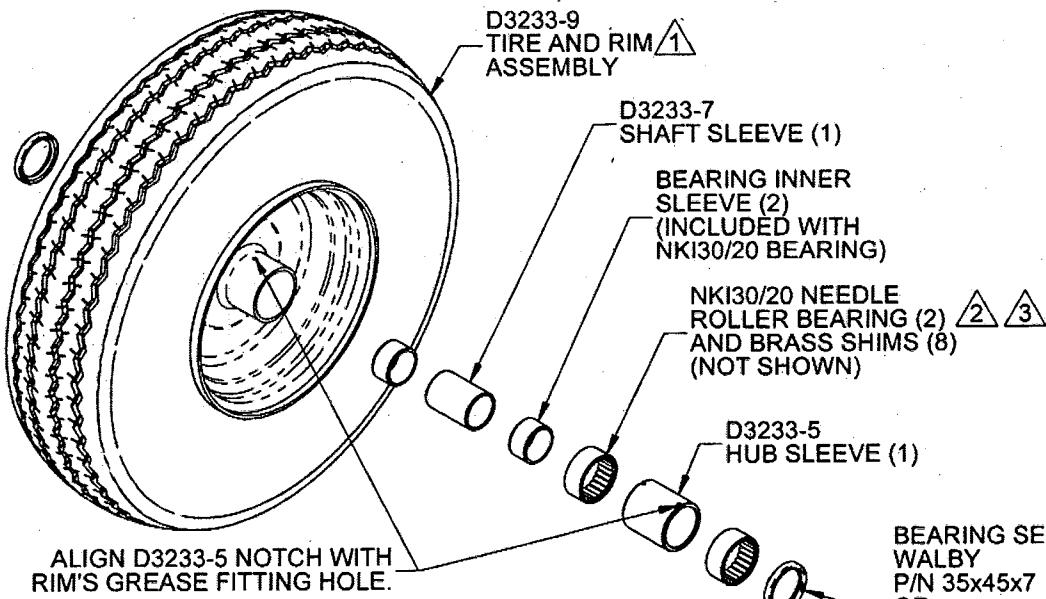
DART

DESIGN <i>b3</i>	DRAWN BY <i>b3</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PF</i>	APPROVED <i>edf</i>	DRAWING NO. D3233	REV. B	SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1	
A 05.02.18		NEW ISSUE		
B 05.03.08		ADDED BEARING SEALS		

**RELEASED**
[Signature]
05/05/04**WHEEL SPECIFICATIONS**

SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0 (RANGE C)	910 LBS	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

1) POSSIBLE SUPPLIER: McMaster-Carr, P/N 8353T74

2) POSSIBLE SUPPLIER: GENERAL BEARING

3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH

(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.

4) POSSIBLE SUPPLIER: GENERAL BEARING

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 112467

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

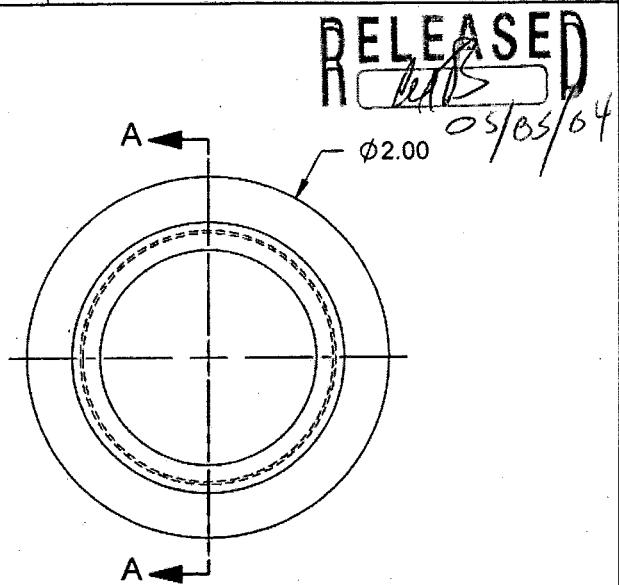
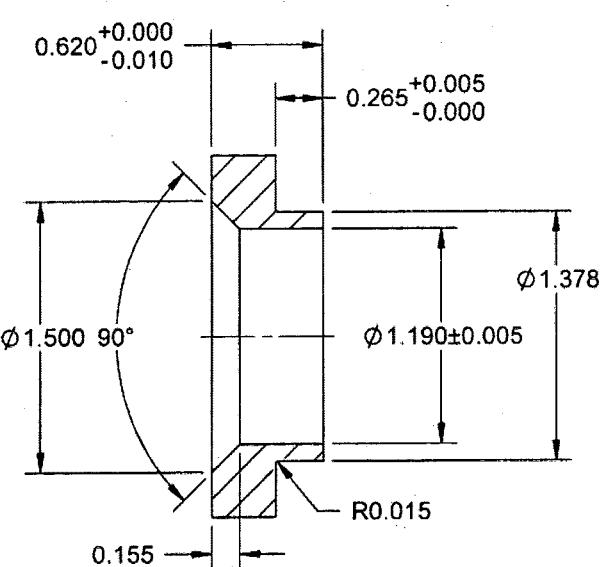
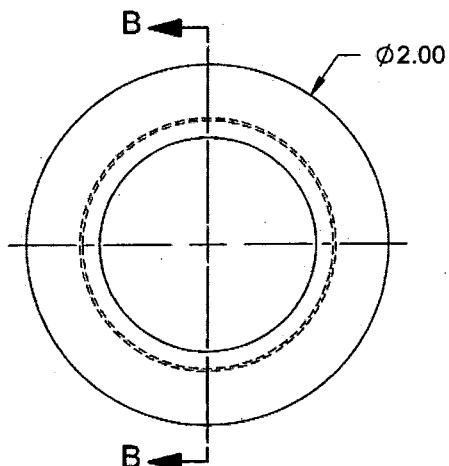
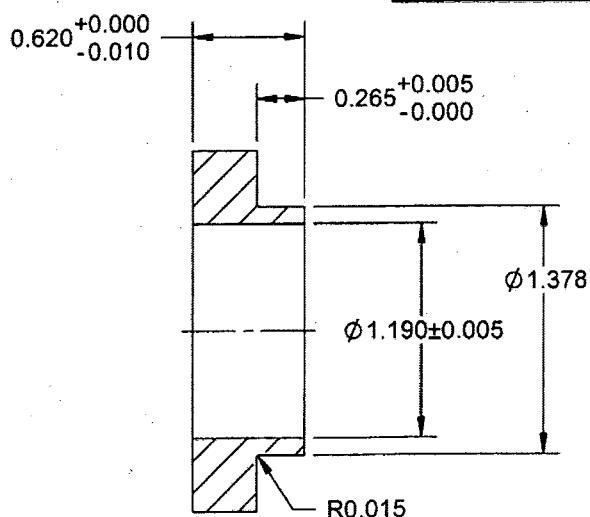
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	05.03.08	D3233	SHEET 2 OF 3

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
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WORK ORDER
NO. 424104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

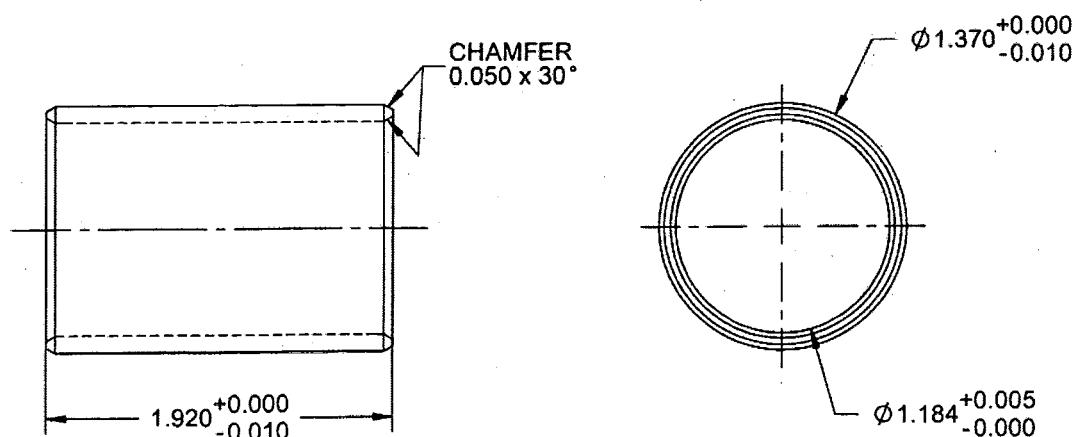
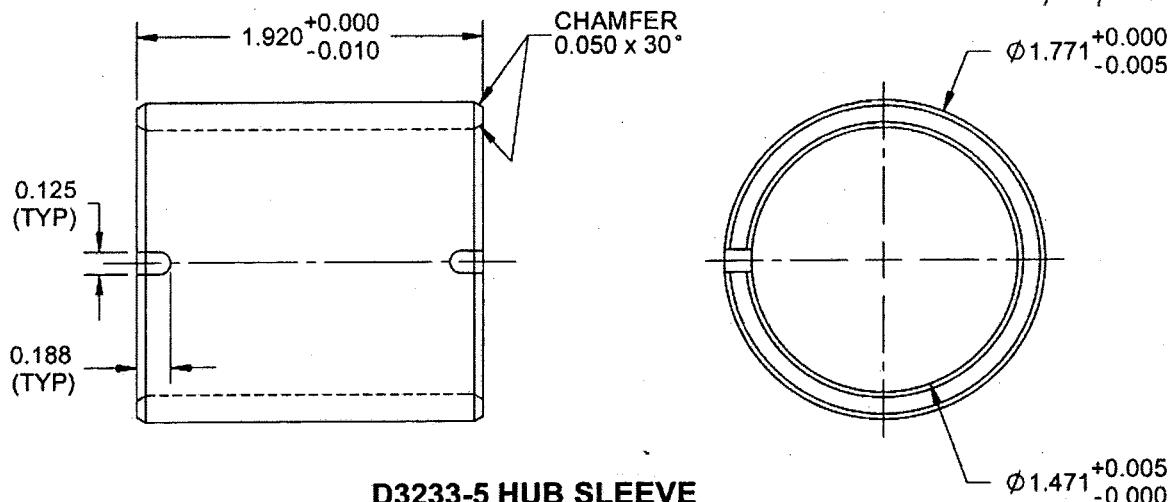
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>b</i>	DRAWN BY <i>b</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PF</i>	APPROVED <i>WPS</i>	DRAWING NO. D3233	REV. B	SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1		

RELEASED
R *WPS*
05/05/04



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESSNTROLLED COPY (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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WORK CENTER
NO. *402701*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries